

# Work Order ID 52803

October 14, 2009 11:32:41 AM



ASAP

Page 1

Item ID: D3798-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: WLF Date: 09-10-14

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3798	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

6061 .050

1-Cut as per Dwg D3798-2  
\*\*\*same flat pattern as D3798-1\*\*\*  
Dwg Rev: B  
Prog Rev: B  
2-Deburr if necessary

HB 9-10-15

①

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

\*\*\*template D3798-1T1\*\*\*

HB 9-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 52803

October 14, 2009 11:32:41 AM



Page 2

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/15/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo ***template D3798-1T1***	0.00  0.00	⇒ S or L 10/15			(X)	✓		
130  Small Fab Small Fab	1- C'sink as per dwg D3798-2 2- Deburr if necessary  Memo	0.00  0.00	⇒ m. L 02/10/15			(1X)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	⇒ S or L 10/15			(X)	✓		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52803

October 14, 2009 11:32:41 AM



Page 3

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/15/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00	Mr L 09/10/15						
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	MP 09/10/15			X1			
170  Small Fab Small Fab	 Memo 1- Assemble D3798-2 to D3798-5 as per dwg	0.00  0.00				E 09/10/15			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52803

October 14, 2009 11:32:41 AM



Page 4

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/15/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo m 109091	0.00 0.00	2) S 02/10/15			0.00 0.00			
190  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo POWDER COAT: Start Time: 1:40 Oven Temperature: 320° Finish Time: 2:10	0.00 0.00	Blk 09-10-15.			0.00 0.00			
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	MD 09/10/15			0.00 0.00			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 52803

October 14, 2009 11:32:41 AM



Page 5

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	10/15/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	Small Fab	0.00							
Small Fab	Memo	0.00							
	1-Install foam as per dwg D3798 using contact cement								
	A/R Contact Cement batch: <u>112225</u>								
	2- Trim foam if necessary								
220 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
230 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

25 09-10-15

2) 801/10/15

(+2) 0

14/10/15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52803**

October 14, 2009 11:32:41 AM



Page 6

Item ID: D3798-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/15

MF  
09-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 14, 2009 11:32:41 AM

Page 1

Work Order ID: 52803

Parent Item: D3798-042RevA **B**

Parent Item Name: Spacepod Floor

Comments:

Start Date: 10/14/2009

Required Date: 10/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

164.5716

9.2568



6061-T6 .050 Sheet

**B 9-10-15**

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

164.5715

110791

34.5715

112567

128

17349

2

**112567**

D3798-5

Manufactured

No

170

Each

0.0000

1.0000



**B 52807**

**SB 09/10/15 \***

Reinforcement

MS20426AD4-34

Purchased

No

170

Each

0.0000

33.0000



**M 15541**

**33+**

**9/30/10/15 ①**

Rivet

D3798-3RevA

Manufactured

No

210

Each

5.0000

1.0000



**ST 09-10-15**

Spacepod Floor Foam

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

5

46206

1

51098

4

**B 52808**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

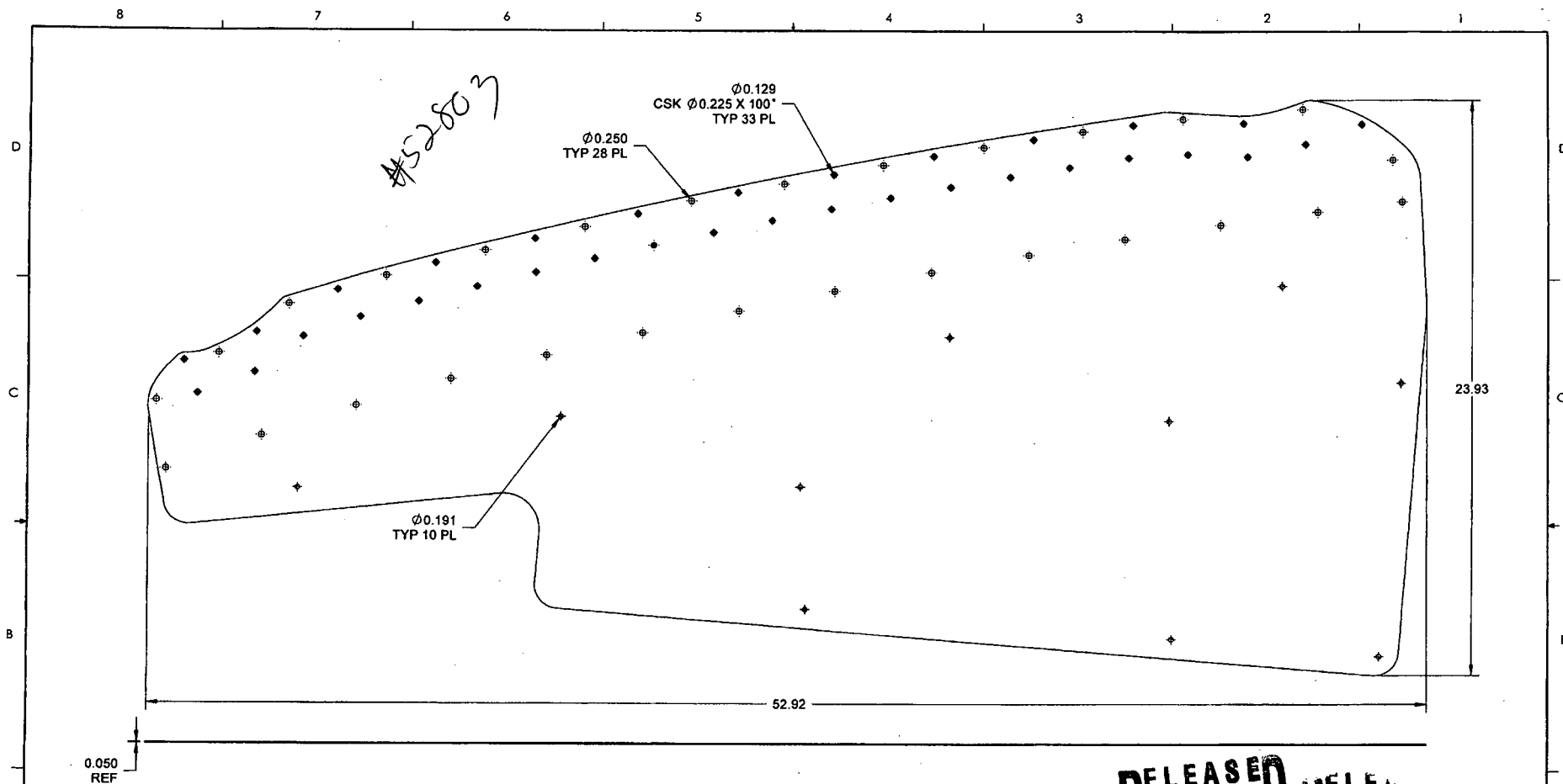
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3798-2 SPACEPOD FLOOR**

**RELEASED** 2009-10-13  
**RELEASED** 2009-10-13

**NOTES:**

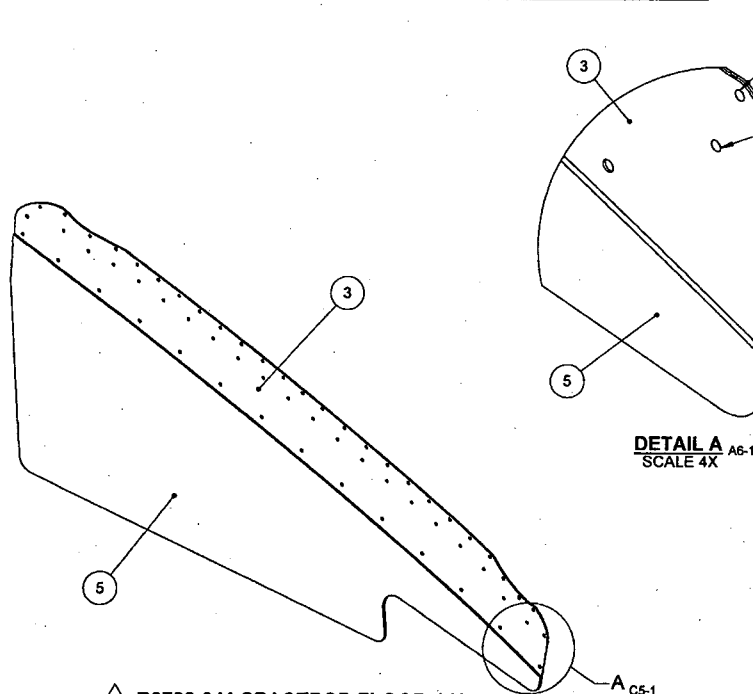
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
 REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

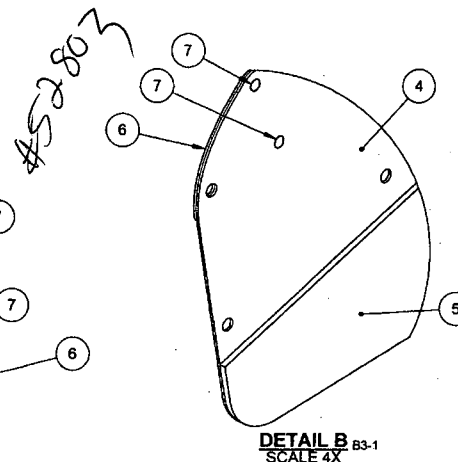


RELEASED  
2009-10-13

ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4	1	1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



**D3798-041 SPACEPOD FLOOR, LH**



**D3798-042 SPACEPOD FLOOR, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs  
D3798-042 - 5.0 lbs
- 8) ASSEMBLY INSTRUCTIONS
  - RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
  - POWDER COAT PER NOTE 2
  - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	